1.50

DART AEROSPACE LTD	Work Order:	21828		
Description: Float Assembly	Part Number:	D3218-041		
Dwg: D3218 Rev. A	Qty:	6		
D3218-041 replaces Helitech P/N: 358-008-001		Page 1 of 1		

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler	H	04.11.02	6
2	PG	Order bags in multiples of 3 Issue P/O: 201075 Supplier: Tulmar Safety Systems D3218-041 Float Assembly per Dwg D3218 Serial No.: BXXXXX-01, BXXXXX-02, etc. Copy of inspection paperwork is required with each Float Assembly	и	o4(1·03	6
3	RG	Receive and Inspect for transit damage Ensure inspection paperwork is provided with each Float Assembly	cL	0411.03	ي
4	QC5	Review vendor paperwork for completeness - Ensure all pressure tests passed - Ensure all dimensions within tolerance - Ensure Dart inspection performed - Ensure s/n printed on bag matches paperwork/Dart W/O Visually inspect bag for defects - No de-lamination or puckering of seams - Girt attachment OK - No holes through stitching - No excess glue - Valves installed in proper locations	05	5-01-0C	6
5	ST	Re-package and Stock in Kwik Float cell	cd.	05/01/12	6
6	AC	Cost / part <u>2276,0 K</u> Close W/O 2 2 76,0 K	Sac	05-01-13	6
7	DC	Close W/O Z Z 76,0 8 Inspect Level 21	1 · N ·	55,01.14	6

Rev	Date	Change	Revised By	Approved
Α	03.11.14	New issue	KJ/DS	#

RELEASED

Dan A	erospace	e Lta							
W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PR	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCF	₹)			
DATE	0750	Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval QC Inspector
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign 8 Date	Sect	tion C	Design Mgr	
_									

Part No:	PAR #:	Fault Category:	_ NCR:	Yes	No	DQA:	Date:	
NOTE: Date & initial all entries				QA: N	1/C C	losed:	Date:	





\	DESIG	af	DRAWN BY	DART AEROSPACE L HAWKESBURY, ONTARIO, CANADA	
	CHEC	KED M	APPROVED A	DRAWING NO.	REV. A
		#	#	D3218	SHEET 1 OF 2
	DATE			TITLE	SCALE
	03.1	0.06		FLOAT ASSEMBLY	NTS
	Α		03.10.06	NEW ISSUE	

RELEASED

D3218-041 FLOAT ASSEMBLY, NOTES:

1) MATERIAL:

ITEM	DESCRIPTION	QTY
FABRIC	POLYURETHANE COATED, PENNEL 987-	7.20 m
	123 YELLOW	
ADHESIVE	SEALREZ S-0345 A/B	2.50 L
WEBBING	LAGRAN #3003, 1" WHITE NYLON	0.31 m
THREAD	NYLON, TWISTED TYPE II, SIZE F, CLASS	5.00 yds
	A, V-T-295, COLOR TAN, CSB 92, COLOR	
ļ	#53	
NYLON CORD	MIL-C-5040 TYPE III, COLOR NATURAL	1.60 m
LETTERING	COATES SCREEN C99 S170 BLACK, HIGH	0.50 oz
•	GLOSS -	
INFLATION VALVE	MIRADA B-51016 / A-51265	2
PRESSURE RELIEF VALVE	MIRADA B-51019	2
TOPPING VALVE	MIRADA B-51209	2
FLANGE	MIRADA B-51014-N (4.25")	4
FLANGE	HALKEY ROBERTS 981001020 (3.5")	2

2) AFTER MANUFACTURE:

- (a) PRESSURE TEST EACH CHAMBER TO 4.36 PSI (30 kPa) FOR 5 MINS.
- (b) INFLATE TO RELIEF VALVE PRESSURE [MIN OF 3.00 PSI (20.6 kPa)]. RELIEF VALVE MUST OPEN AT 3.3-3.5 PSI AND MUST CLOSE AT NOT LESS THAN 3.00 PSI. BAG MUST MAINTAIN A MIN PRESSURE OF 1.6 PSI (11.0 kPa) FOR 24 HOURS.
- 3) FLOAT IDENTIFICATION LETTERING 0.313" (7.95mm) HIGH BLACK CAPITAL LETTERS STENCILED ON THE R/H SIDE OF THE FLOAT BAG AS FOLLOWS:

DART AEROSPACE LTD.
FLOAT ASSEMBLY
P/N D3218-041 S/N BXXXXX-XX
REPLACES HELITECH P/N 358-008-001

SHOP COPY

RETURN TO

4) COATED SIDE OF FABRIC ON OUTSIDE OF BAG.

5) ALL DIMENSIONS ARE IN INCHES. CRITICAL DIMENSIONS (DENOTED BY 5) TROLLED COPY MUST BE OBTAINED AT 2 PSI.

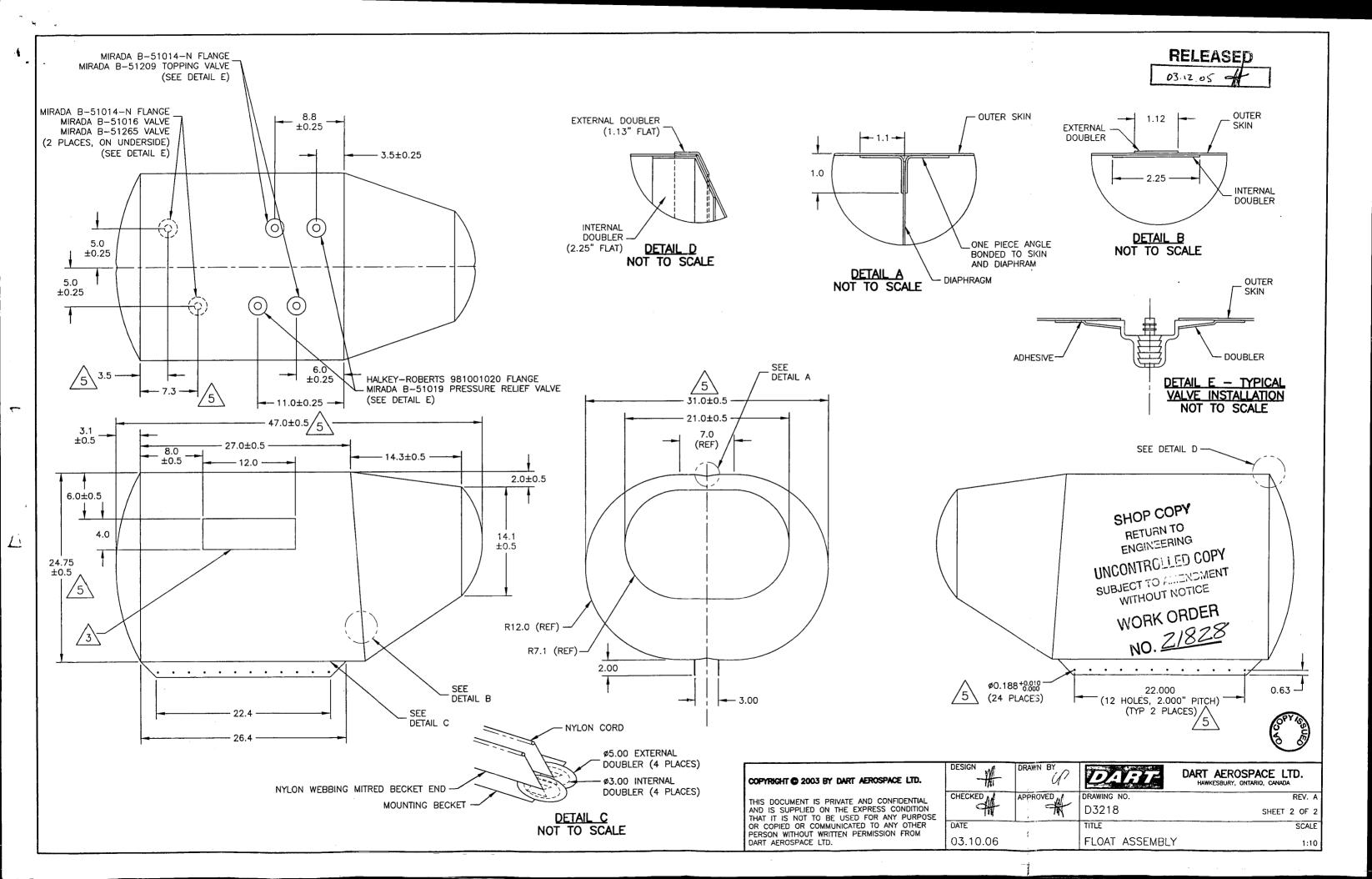
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

NO. <u>21828</u>

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Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Nov 02, 2004 02:36 pm

Work Order No : 0021828

Project Name : D3218-041
Project For : WK450
Work Order Type : Main
Main WO Number :

House Part Number : D3218-041 Description : Float Assembly

Manufactured : Yes

Amount Req'd: 6
Amount Done: 0
Start Date: 11-02-04
Est Finish Date: 12-03-04

Act Finish Date :

Drawings Reqd : No

Ok for Approval :

Approval Rec'd :

Department Code: Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No : OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	= = : :	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
		========	=======	======		
Total Cost	:	0.00	0.00	0.00		
Margin	:	0.000	0.000			
Selling Cost	:	0.00	0.00			

Estimated Actual Labour Hrs/Amount Done : 0.00 Profits/(Loss) : 0.00 0.00 0.00

Revision 1/10/96 Form 457

TULMAR SAFETY SYSTEMS

1123 Cameron Street Hawkesbury, Ontario, Canada K6A 2B8

TEL: (613) 632-1282 FAX: (613) 632-2030

Sold To

Shipped To

DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613-632-9577

Date	Your Order No.	Shipped Via	No. Containers	Gross Weight	Reference No.
12/6/2004	2007075	Our Truck	1 Box	kg	W/O 14699 P/S 10190

Part No.	Item	Quantity	Qty Shipped	Balance	Description	Release No.
		0	0	0		
TSS8927	1.	6	6	0	FLOAT ASSY, individual bag	
		0	0	0	P/N D3218-041 Rev A	
		0	0	0	S/N: B21828-01, B21828-02, B21828-03,	
		0	0	0	B21828-04, B21828-05, B21828-06	
		0	0	0		
		0	0	0		
		0	0	0	·	
		0	0	0	Release Note: R92-10070	
		0	0	0		
		0	0	0		
		0	0	0		
		0	0	0		
		0	0	0		
		0	0	0		
		0	0	0		
		0	0	0		'
		0	0	0		
		0	0		DART AEROSPACE LTD	

SHIPPER Daniel Gelineau

Release Note

TULMAR SAFETY SYSTEMS INC.

1123 Cameron Street,

Hawkesbury, Ont. Canada K6A 2B8

Tel: (613)632-1282 Fax: (613)632-2030

Sold To:

Revision 05/08/01 Form 458

R/N No.

R92-10070

Date:

12/6/2004

Shipped To:

DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

	Your Order	Conve	yance	0	ur Order N	lo.	P/S No.	
20070	75	Our Truc)	10190		
Item	Description	Qty Ordered	Spec'	n No.			ming se No.	Batch
1.	FLOAT ASSY, individual bag	6	TSS89	27	6			
	P/N D3218-041 Rev A	0						
	S/N: B21828-01, B21828-02, B21828-03,	0						
	B21828-04, B21828-05, B21828-06	0						
		0						
		0						
		0						
		0						
		0						
		0						
	·	0						
		0						
		0						
	If any questions or concerns please contact	0						
<u> </u>	Linda Presseault, QA Mgr 613-632-1282.	0						
		0						
		0						

I hereby certify that the items listed hereon have been inspected, tested, and conform to all specifications and requirements detailed in the contract or purchase order.

12/6/2004

Authorized Inspector

Date

TULMAR

Tulmar Safety Systems Inc.

1123 Cameron Street

Hawkesbury, ON K6A 2B8 CA

Tel:

613-632-1282

Fax:

613-632-2030

Bill To

Dart Aerospace

1270 Aberdeen Street . Hawkesbury, ON K6A 1K7

CA

Order No 14699

Order Date

Page

5-Nov-04

1

Customer Purchase Order

2007075

Contact:

Ship To

Dart Aerospace

1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Dear Customer, This document acknowledges receipt of your order. Please review the information presented here and advise us of any errors you notice or disagreements you have at your earliest convenience. For fastest service, write or call us at the address and phone number printed above. Please refer to our Order Number and your P.O. Number in all correspondence.

Customer

Payment Terms

Ship Via

CDART100

Net 30 Days

Pick-Up

PPD/COL

Shipping Instructions

FOB HAWKESBURY

Item No

Ship Date

3-Dec-04

Quantity

UOM

Unit Price

Extended Price

8927

Float Assembly, individual bag

P/N: D3218-041

P/N .D3218-041

Revision A

Must use Sealrez S-0345A/B adhesive.

5/0: Baisas -01/02/03/04/05/04

abby No. 23,04 SAL

e Dec. 6/04

B 21828 -01

_ 02

-03

- 0 Y

-05

-00

Sales amount:

Sales tax:

Total

F. 3663

LMAR

Product Inspection Form # 193-8927(Tube & Final)

Rev. D. Sheet 13

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected LA.W. P.I.P. 001

W/O: 3663 TSS P/N: 8927 Qty.: 1 Customer P/N: <u>D3218-041</u> Dwg. No.: <u>D3218</u> Rev.: Δ Date: <u>Nov. / α 4</u>

Cutting IAW PCS 003		Marking IAW PCS 004		Rond	ing IAW PCS 002				
	Operator No.	Date	Operator No.	Date				Silkscreen	_
			1 = 1		Operator No.	Date	Operator No.	Date	:
	2 Y 5-	And I lie	1-23 /3/	NOV04	7.7			-	
		100/09			<u> </u>	nented below)			
	* Note: PCS and	41							

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total	Insp.	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	37 10 nov. 4	7104-24	1	<u>- X0:</u>		Accept.	(9	Nov.10/04
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	37 10 nov. c4		6			61		Nov. 10/04
c) Attach (6) Doublers on above Flanges	37 10 nev.04	Bonding	6		_	6	I I A	9 460.10/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 10 NOV.04	6	1			. ((9)	Nov. 10/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 10 nov. 04	,	j		7 74 BA-4-44		(9"	Nov. (4/04)
4- a) Baffle Ass'y, with 2" Tape ± 1/8"	117 10 20004	7/04-24 Bonding	1	_		/	(8)	710010/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	11 nov 04	7104-25	1			/	130	Nov 11/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	NOV 16/04	Testing (see sheet 2)	,				185	,
7- a) Closure of 1" Main Scam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)	37 17 nov. 104	7/04-25 Bonding.	1		_		為	NOV 16/04 NOV 17/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	Dec 3/04	Testing				((AS	Dee 3/04
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main	Nov 23/04	(see sheet 2)			-		4)	Nov 22/04
Scam, Centered ± 1/8"	Nov. 23/04	7104-25	/			1	1	Nov. 23/04;
L → 7 AUaCh 2 Split natch on each end (v 4)	Non-23/04	Bonding	/			_/_	11)	Nov 24/04.
37	Nov 23/04					/ ()		Nov 24/04

CIII MAR H	, e ^r	
	<i>CULMAR</i>	·H

Rev. D. Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch:	12 NOV 30/04	Testing			-	((4	Nov 30/04
Serial No.: B 2 / 8 2 8 - 0 1		(see sheet 3)			_	,	(ASS	
& Inspection Stamp beside the S/N21828-01	12 Dec 6/04		/	J. D. D. D. Cred	or to W(0)	* Verify the in	territy of the	1 DEC 6 / 84 Valves (Threads/gaskets).

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high legering and black ink: serial number (7 digits), provided by DART

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- = 0.049 PSI for each 0.1 inch of barometric decrease

		5 Min. Over P. & Soap Test	(45 Minute			1 Hour Test							
Chambers	Pressure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Readig	Pass Tail
# 1 (see note 1)	4.36 PSI	Pass	3,00 PSI	1:45	à:30	3.00 PSI	2:30	3:30	3.00 PSI	24 24	30.14 30.14		3,00 PSI	Pass.
Re-Test														
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	8:20	9:05	3.00 PSI	9:05	10.05	2.96 PSI	21 21	29.94 39.94		2.96 (SI PSI	fass
Re-Test														

Note 1: Chamber # 1 requires Dart Aerospace Ap	proval Signature:	ot opplicable	e A?	Date:	
Observations:					

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2). The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		O _I	ocning	Clos	<u></u>	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	32856	12, 55	3.50 PSI	12.58	3.07 PSI	Pass
Chamber # 2 (Main Seam)	32865	1:00	3.42 PSI	1:05	3,19 PSI	Pass

Chambers	Design (closing) Pressure				24 Hour I	cakage Test		22	% hum.
Nov35/04	as per above	Time On	Time Off	Read'g	Temp. Start/End	, Barom. Start/End	Adjust.	Final Read'g	Pass Fail
# 1 Re-Test	3.07 PSI	12:58	12:58	2.18 PSI	23	29.10 29.80	+ 0.343	2.46 PSI	Paes
# 2 (Main Scam) ************************************	3,9 PSI 3,19	1:05	1:05	1.40 PSI	22 22 23 22	29.80 30.05 30.01 30.06	+ 0.122 + 6.054 - 6.004	1.52 PSI	Fail Pass

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3 1/2	Pass	47.0	± 0.5	46 7/8		24.75	+ 0.5	25	Pass
[7.3	1.0.100 *	1 /2	1 Pass	* = IAW	QSI 018 are	v. A dated 03-05-29		31.0	105	3/	Pass

ļ		Subm.Date / am@m	Pass/Fail	Subm.Date / @Ppm	Pass/Fail	Subm.Date / amூற்	Pass/Fail	Subm.Date / am-pm	Pass/Fail
lee –	24 hour	110010/04	Paso	710017/04	Pass	70023/04	Pass		
	7 day	7100 18/04	Pass	710017/04	Pasa	Trov 23/04	Pass		
ear	24 hour	10010/04	Pass	710017(04.	Pass	70023/04	Pass		
, Sh	7 day	nov 10/04	Pass	nes 17/04	Piers	nov 23/04	Pusa	·	

TULMAR

Product Inspection Form # 193-8927(Tube & Final)

Rev. D. Sheet 1.3

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

w/o: 3663

TSS P/N: 8927

Qty.: 1

Customer P/N: <u>D3218-041</u>

Dwg. No.:D3218

Rev.: A

Date:

Nov/04

Cutti	ng IAW PCS 003	Mari	king IAW PCS 004				
Operator No.	Date	Operator No.	Date		ing IAW PCS 002		Silkscreen
			77	Operator No.	Date	Operator No.	Date
65		125-157	1104				
-83	would	 		l (Docui	nented below)		
<u> </u>					1222000 001011		
* Notes DCC noc	46. 1 100		· · · · · · · · · · · · · · · · · · ·	L	L		-

^{*} Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions

Operator

Operator

Accept, Reject

Total Justin

Stages & Descriptions	No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp.	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	37 Nav.11/4	2	/		_	/(CCp).	Stamp	NW-11/04
b) Attach (6) Valve Flanges on Panel Λ: 2-Relief, 2-Inlet & 2- Topping Up	\$ 90 -Nov. io/o	4 4104-25	6	P	_	6	0,0	100.10/04
c) Attach (6) Doublers on above Flanges	\$0 - NOV. 19/01	Bonding	6			6		101.10/04
2- a) Attach Panel C to Straight edge of Panel Λ, centered on a 2" inner Tape (butt joint) ± 1/8"	37 Nov.11/04	, .	1			1	(15)	Nov. 11/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 Nov 11/04	<u>′</u>	/				(15)	
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	117	7/04-25 Bonding				, (≈\S6Y _	
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117	Bonding					(VSS)	Nov.18/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12	Testing					X S S	Nov11/04
	16 mov 04	(see sheet 2)			_	1	LAVI	NOV 16/04
7-\(\sigma\) Closure of 1" Main Scam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)	16 nav. 04	7104-25 Bonding	1	_		/	(FFF)	nov 16/04
	Dec 3/04		1	_	_		1	Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time		Testing					XS'SX	Dec 3/04
	NOV 22/04	(see sheet 2)	<u> </u>	_		1 1	4/	Vor 22/04
9- a) Attach I" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	137 Nov.22/04	1104-25	,			/ /	ا ﴿ منب ﴿ ا	Nov. 23/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	Non 1-24/04	Bonding					74-1	Nov-24/04
c) Attach 5" split natch on each end (v 4)	7 NOV 24/04	7/04-25					ויטי	· · · · · · · · · · · · · · · · · · ·
	1000 27104					_ / /		Nov 24/04

Rev. D. Sheet 23

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp.	Date
10- a) Final Test b) Inspector to Stamp on ID Patch:	12 NOV 27/04	Testing					4 ASS	
Serial No.: B 2 1 8 28 - 02	9 12-200-1	(see sheet 3)	,			1	4	Dec 6/2009
the completion of the (final) leakage test, the ID Patch shall be stamped with 5/16"	high achtering and black	V k ink: serial number (7	digits), provide	d by DARI (re	fer to W/O).	* Verify the in	tegrity of the	Valves (Threads/gaskets).

Test Conditions - All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.049 PSI for each 0.1 inch of barometric increase
- ± 0.054 PSI for each 1°C of temperature decrease
- 0.049 PSI for each 0.1 inch of barometric decrease

		5 Min. Over P.	I				,			: 1 He	our Test		1:	5 %.
Chambers	Pressure	& Soap Test Pass / Fail	Sta Design Pressure	bilizing Per Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass ' Fail
# 1 (see note 1)	4.36 PSI	Fail	3.00 PSI			3,00 PSI		-	PSI				PSI	
Rc-Test		Poss	3.00	9:15	10:00	3.00 B1	10:00	11:00		24 24	30.16 3014	-0.02	2.96 61	ł
# 2 (Main Scam)	4.36 PSI	Pass	3.00 PSI	8:15	9:00	3.00 PSI	9:00	10:00	2. 99 PSI	21 21	29.94 29.94	7-	PSI	Pass
Re-Teșt											<u> </u>		<u> </u>	<u></u>

Note 1: Chamber # 1 requires Dart Aerospace	A Cimptura: Mo T	andiable	<i>A</i> :	Date:
Note 1: Chamber # 1 requires Dart Aerospace	Approval Signature. /////	apparer a		
Observations:				

IULMAR #2

Product Inspection Form # 193-8927(Tube & Final)

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief			ening	Clos		
Chamber # 1	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 2 (Main Seam)	32853	Q.4.5	3.34 PSI	4:50	3,09 PSI	Pisa
Chamber w 2 (Main Seam)	1 31660	12:50	3.44 PSI	12:55	3.22 PSI	Riss

Chambers	Design (closing) Pressure	·	24 Hour Leakage Test								
Nov25/04		Time On	ime On Time Off		Temp. Start/End	. Barom. Start/End	Adjust.	Final Read'g	Pass Fail		
# 1 Re-Test	309 PS	12:50	19:50	2.22 PSI	23° 22°	29.10 29.79	+0.338	2.49 PSI	Piss		
# 2 (Main Scam) Rc-Test	3.22 PSI	12:55	19:55	1.76 PSI	<i>əa</i> ′ <i>ə</i> a	29.80 30.05	+0.122	1.88 PSI	foss		

Dim. Tol. Actual Di	n. Pass/Fail Dim.	Tol. Actual Dim	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5 ± 0.100 * 3.5	fogs 47.0	± 0.5 46 7/8	Ress	24.75	10.5	25 1/16	Pass
7.3 ± 0.100 * 7.5	*= 1A	AW QSI 018, rev. A dated 03-05-	29	31.0	1 0.5	31 1/4	Pass :

		Subm.Date / am 🔞	Pass/Fail	Subm.Date / am-@p	Pass/Fail	Subm.Date / am-@	Pass/Fail	Subm.Date / am pm)	Pass Fail
3	24 hour	nov10/04	Pass	now 11/04	pass	new 16/04	Pass	nev 22/04	Pasa
d	7 day	nov 10/04	Pass	nov 11/04	puss	70016/04	Pass	100 22/04	Russ
, g	24 hour		7	200 14/04		nov 16/04	Pass	nav. 22/04	Pass
She	7 day				′		· · · · · · · · · · · · · · · · · · ·	7	1.00
*************************************				novillay	Pass	10016/04	Puss	nov 22/04	Pass

Rev. D. Sheet 3.3.

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

	Pressure Relief Valve Test PRV Serial Numbers						pening			Closin	g		!
			PRV Serial	Numbers		Time ON	Pressure		Time			Close	Pass Fail
Chamber #								PSI				PSE	
Chamber #	2 (Main Seam)						PSI				PSI	
<u> </u>												····· 	l
Chambers	Design (closing) Pressi						24 Hour Lo	akage Test		And the second s			
	as per above Time On PSI				on	Read'g	Temp. StarkEnd		om. Ænd	Adjust		Linal Read g	Pass Lad
#1	I	'SI				PSI						PSI	
Re-Test								<u> </u>	:				
# 2 (Main Seam)	J'	'SI				PSI			<u>.</u>			PSI	
Re-Test													
		-tamer the		**************************************		<u> </u>						·	I
Dim.	Tol.	٨	ctual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	1 101	- I A	ctual Dim.	Pass Fail
3.5	F 0.100 *				47.0	+ 0.5			24.75	Tol. ± 0.5			
7.3	± 0.100 *				* =		v. A dated 03-05-29	.1	31.0	+ 0.5			-

	,	Subm.Date / @ppm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm Date / am-pm	Pass Fail	Subm.Date	am-pni	Pass Laif
eel	1 ~	nov 24/04	Pass						1	
<u> </u>	7 day	now 24/04	Pass				7 8 71 75 1 1 6 865 1 5 1 666 1			i i
T na	24 hour	700 24/04	Pass							
S.	7∢day	novay/04	Pass	·		,				

Rev. D. Sheet 1.3

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected LA.W. P.I.P. 001

TSS P/N: 8927

Qty.: 1

Customer P/N: <u>D3218-041</u>

Dwg. No.: <u>D3218</u> Rev.: A Date: VCV

Cutti	ng IAW PCS 003	Marki	ing IAW PCS 004	Bondii	ig IAW PCS 002	Silkscreen		
Operator No.	Date	Operator No.	Date ,	Operator No.	Date	Operator No.	Date	!
		125-157	var/ /54			-		
755-	Mich / cy			(Docum	nented below)			- · ·

^{*} Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	37 11 MCU.CY		1		-	1	1	NOV 11/04
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	#10 revujo4		6	رجي.		6		nev:1/02
c) Attach (6) Doublers on above Flanges	47 47	Bonding	W	_		4,0		Nov. 11/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 ((nev.04)	4104=25	1		_	((15.0°)	Nov. 11/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 11ncc. (2)	<u>.</u>	1			1		1100.11/04
4- a) Baffle Ass'y, with 2" Tape ± 1/8"	117 112004	7/04-25	,	_		,	(38)	210011/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117 12 novo4	Bonding 7104-25	1			/	J	Nov., 2/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 15morray	Testing (see sheet 2)	1	+		1	(A)	nlos 15 hu
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	3+ 16 NEU , C4	7109-25	/	F-1000-		/	(38)	Nov 15/04
b) Attach ID Patch (ref. CAR 04-003)	37 Dec 3/04	Bonding .	1			((1)	Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12' Nov 30/09	Testing (see sheet 2)				1	(5.8)	
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"		7104-25	a second					Nov 23/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	Nov 24 104	Bonding				/ (150	War 24/04
, c) Attach 5" split patch on each end $(x 4)$ 37	Nev 24 04	7104-25	1 -		-	_ /		NOU 24/04

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test	12 20/04				! -	<i> </i>	(4)	ルからわらいり
b) Inspector to Stamp on ID Patch:		Testing			: [
Serial No.: B 2 / 8 2 8 -0 3		(see sheet 3)			· -		(55)	
& Inspection Stamp beside the S/N21828-05	12 De(6/3	1004				(14	Dec 6 2004
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " hig	h lettering and black	ink: serial number (7 e	ligits), provided	by DART (refe	r to W/O).	* Verify the int	egrity of the V	alves (Threads/gaskets).

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

CI. I	D	5 Min. Over P. & Soap Test	i .	45 Minute bilizing Per		1 Hour Test					1 Hour Test			
Chambers	Pressure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Readig	Pass 'Fail
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	1:45	2:30	3.00 PSI	ā.30	3:30	3.00 PSI	24 24	30.30 30.20	0	3 O PSI	Person
Re-Test				,										
# 2 (Main Seam)	4.36 PSI	ass	3.00 PSI	8:10	8:55	3.00 PSI	8:55	9:55	<i>3. 0</i> PSI	21 21	2994 22.94		3. o fsi PSI	Pari
Re-Test		•												

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	mot	applicable	XP.	Date:	
Observations:	/	<i>(/</i>			

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Оре	ening	Clos	İ.,	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass Fail
Chamber # 1	32861	12.55	3. 44 PSI	1:00	3. 24 PSI	Poss
Chamber # 2 (Main Seam)	32855	1:05	3,45 PSI	1.10	3, 28 PSI	Casu

Chambers	Design				24 Hour Le	cakage Test	-	23 ⁶ /	6 Kuny	
Nev-25/04	(closing) Pre- as per abo	13	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Readig	Pass Tail
# 1	3.24	PSI	1100	1:00	2.51 PSI	23 22	29.10 29.80	- 0.051 - 70.343	2.79 PSI	Piss
Re-Test										
# 2 (Main Scam)	328	PSI	1:10	1:10	2.04 PSI	22 22	39.80 30.05	+0.120	2.16 PSI	Passi

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass Fail
3.5	上 0.100 *	3,5	Pass	47.0	± 0.5	47 1/8	fiss	24.75	10.5	25	Poss
7.3	上0.100 *	7, 3	Pass	* = IAW	/ OSLOTÉ re	v. A dated 03-05-29		31.0	1.0.5	31 1/16	Fass
			,	٠٠	Just -	v. 77 dated 05 05 27			• • • •		, ,

		Subm.Date / ơౖฏî-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm Date բam-ընթ	Pass Lail
leej	24 hour	hec 11/04	Pena	7100 11/04	7) and	716012/04	11:24	118016/04	1
d.	7 day	nov 11/04	Pan	720,11/04	,	nav 12 1/04	Para	710016/04	- Mine
ia f	24 hour	710011/04	Pass	nev 11/04		na 12/04	11000202	710- 16/04	20.2-2
•She	7 day	700 11/04	Pásis	no. 11/04	/	116U 12/04	Fina	710016104	Pare

Res D. Sheet 3.3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non-detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closine time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, (afe the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The-corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief						pening			Closing			
V	ilve Test		PRV Seria	l Numbers		Time QN	Pressure		Lime	.	Close	Pass Lad
Chamber#	1							PSI			1251	
Chamber #	2 (Main Seam)							PSI			
Chambers	Design						24 Hour L	eakage Tes	(TO THE PERSON OF	
Chambers	(closing) Press as per above		Time On	Time (off	Read'g	Temp. Start/End	Ba	rom. tā nd	Adjust	Linal Read's	Pass Full
# 1	1	'SI				PSI					1'81	
Re-Test												
# 2 Main Scam)	1	'SI				PSI					PSI	
Re-Test												
					•							,
Dim.	Tol.	٨	ctual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail		Fol.	Actual Dim	Pass Lad
5.5	F0.100 *	·			47.0	4 0.5			24.75	1.0,5		
7.3	[+0.100 *]] * =	= IAW OSL018 rev	v. A dated 03-05-29		31.0	0.5		

		Subm.Date /@it-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pars Fail	Subm.Date	am-pm	Passlan	11
2	24 hour	7160 24/04	Para							- I	
Ъ.	7 day	7100 24/04	Paux								
. י	24 hour	7100 24/04	Pais						,		
She	7, day	nov 24/04	Pass								

Rev. D. Sheet 1.3

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

TSS P/N: 8927

Qty.: 1

Customer P/N: <u>D3218-041</u>

Dwg. No.: $\underline{D3218}$ Rev.: $\underline{\Lambda}$ Date: $\underline{Nov/ox}$

	ing IAW PCS 003	Mark	ing IAW PCS 004	Bondii	ng IAW PCS 002		Silkscreen
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
Le -		1=5-157	100 /cy				
1.15	Now for			(Docun	nented below)	19114	
<u> </u>		l <u></u>					

* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total	Insp. Stamp	Date
 1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8" 	37 15 NOV. 04		/	-		Accept.	(5)	Nov 15/07
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	90 ner Hoy	,	(c	_		6		Noc. 15/04
c) Attach (6) Doublers on above Flanges	90 xex stoy	Bonding	6		-	6		WW.15/01
2- a) Attach Panel C to Straight edge of Panel Λ, centered on a 2" inner Tape (butt joint) ± 1/8"	37 15 nov/04	7104-25	1					1/20 15/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 15 nov/04		/					War stet
4- a) Baffle Ass'y, with 2" Tape ± 1/8"	117 15 novo4			•		<u>-</u> -		1000.15/04
5- a) Attach Baffle Ass'y, to Bag (in 3 stages, minimum)	117 16 20004	Bonding	/					1/1/2/2/
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 NOV 35/04	Testing (see sheet 2)	/					
7- a) Closure of 1" Main Scam (overlap) ± 1/8"	22 nov /04	フ/04 25 Bonding				/	Zex	Nov Doloy.
b) Attach ID Patch (ref. CAR 04-003)	Dec 3/04	Donaing .			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	(Dec 3/04.
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	NOV 25/04	Testing (see sheet 2)	1		_	(, ,
9- a) Attach I" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	37 D6 Nov 104	7104-25	- 		in a second	·	(LE.S.)	1/07-25/04.
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	37 26 nev c4	Bonding					NEW Y	Mbv.2404
Attach 5" split patch on each end (x4)	37 26 nov 1	ļ-	1					

Rev. D. Sheet 2.3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Accept.	1 <u>4</u>	Date
10- a) Final Test	2 Decipor	1	!			!	1	Deep 1/2 509
b) Inspector to Stamp on ID Patch: Serial No.: B 2 1 8 2 8 - 0 4		Testing (see sheet 3)					KS5	
& Inspection Stamp beside the S/N 21 828-0	4				- W(O)	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		Dece / Kor

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high lettering and black ink; serial number (7 digits), provided by DAR1 (refer to W/O) - 5 Verify the integrity of

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

- + 0.054 PSI for each 1°C of temperature decrease
- = 0.049 PSI for each 0.1 inch of barometric decrease + 0.049 PSI for each 0.1 inch of barometric increase

		5 Min. Over P. & Soap Test	l	45 Minute bilizing Per						1 He	our Test		1	ī .
Chambers	Pressure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/Fnd	Adjust.	Final Readig	Pass Fad
# 1 (see note 1)	4.36 PSI	Pasw	3,00 PSI	8:45	9:30	3,00 PSI	9:30	jo:30	3. PS1 PSI	ત્રાં હા	29.93 54.93		3 R.	Reas
Re-Test												=		<u> </u>
# 2 (Main Scam)	4.36 PSI	Fail.	3.00 PSI			3.00 PSI			PSI				PSI	
Re-Test		Risa	3,00	1:10	1:55	3.00	2:00	3:00	2.98	230 23	29.13 29.19	Fo.ck	3 PSI	Pass

			Λ	
Note 1: Chamber #	1 requires Dart Aerospace Approval Signature:	Chris Promes	<u> </u>	Date: 09/1/17
Observations:				

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Оре	ning	Clos		
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	<u> </u>	10:30	3 48 PSI	10:35	3 17 PSI	Pass
Chamber # 2 (Main Seam)	32847	10:40	3.46 PSI	10:45	3.19 PSI	Passi

Chambers	Design (closing) Pressure				24 Hour L	eakage Test		14	% humas
	as per above	Time On	Time Off	Read'g	Temp. Start/End	. Barom. Start/End	Adjust.	Final Read g	Pass Fail
# 1 Re-Test	3.27 PSI	10:35	10:35	2.02 PSI	22 22	30.12 30.04	-0.039	1.98 PSI	Pass
Wor 30/04 #2 (Main Scam) Re-Test	3.19 PSI	10:45	10:45	2.37 PSI	33° 33°	30-05 29.19	-0.421	1,94 PSI	Pass

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass Fail
3.5	± 0.100 *	3.5U	Pass	47.0	+ 0.5	41:0	12.53	24.75	1 0.5	25.23	7635
[1.3	1.0.100 *	7.25	1365	* = 1/W	QSI 018, rev	v. A dated 03-05-29		31.0	+ 0.5	31.78	7333

		Subm.Date /@nj-pm	Pass/Fail	Subm.Date / amերիր	Pass/Fail	Subm.Date / agi-pm	Pass/Fail	Subm.Date (ampni)	Pass Fail
H	24 hour	now 15/04	y'ans	110015/04	Para	110016/04	1.26.22.	nac 30/14	11-1-1
	7 day	nav 22/04	Porsa	-xac 23/04	Poss	10016/04	Pazz	1	1'ans
ear	24 hour	7100 15/04	Paul	7100 15/04	Paux	750016/04	planter 2	7100 Dalet	10.22
Sh	7 day	-xau. 25/04	Porg	xav 22/04	Foras	Yes 16/04	Pass	Mai 37/4	prosession

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Oper	ning	Closing			
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail	
Chamber # 1			PSI		PSI		
Chamber # 2 (Main Seam)			PS1		PSI		

Chambers	Design (closing) Pressure		24 Hour Leakage Test											
Chambers	(closing) Pressure as per above	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail					
# 1	PSI			PSI				PSI						
Re-Test														
# 2 (Main Scam)	PSI			PSI				PSI						
Re-Test														

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	•		47.0	± 0.5			24.75	± 0.5		
7.3	± 0.100 *			* = IAW	/ OSI 018, re	v. A dated 03-05-29		31.0	± 0.5		

		Subm.Date / am-pm	Pass/Fail						
eel	24 hour	Thou :26/04	Pan						
۵.	7 day	700 26/04	Pass						
är	24 hour	nov 26/04	Puss					·	
She	7 day	nev 26/04	Pusa						



Rev. D. Sheet 1.3

Des

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/0:<u>3663</u>

TSS P/N: 8927

Qty.: 1

Customer P/N: <u>D3218-041</u>

Dwg. No.: <u>D3218</u>

Rev.: <u>A</u>

Date:

-	ng IAW PCS 003	Markit	ng IAW PCS 004	Boi	nding IAW	PCS 002		Silkscreen		
Operator No.	Date	Operator No.	Date	Operator No		Date	(Operator No.	1	Date
8 5 Note: PCS 006,	there shall be a total of		for the Testing of the A	(Doc	umentec Shear Test			every produ	ection day,	record on sheet 3
	escriptions	Operator	Operation	Accept. Qty.	Reject. Qty.	·	Total Accept.	Insp. Stamp	Date	
	Panel A (uneven edge) to	37 15 nov-04		,			/	· •	NW.15/04	

St	ages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1-	a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	37 15 nov-04		1			1		NW.15/04
	b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	90 Nov. 15/04		(e	_		6		Nov.15/04
	c) Attach (6) Doublers on above Flanges		Bonding	6	_	_	ري	So	Nov.15/04
2-	 a) Attach Panel C to Straight edge of Panel Λ, centered on a 2" inner Tape (butt joint) ± 1/8" 	37 15 Nov. /04		1			1 (11	Nov.15/04
3-	a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 15 nov. 04		/			,	(11)	Nav. 15/04
4-	a) Baffle Ass'y, with 2" Tape ± 1/8"	117		/			,	(age)	now 16/04
5-	a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	117 16 novo4	Bonding	j	,		/	ALS,	Nov. 16/04
6-	a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 NOV 22/04	Testing (see sheet 2)	,		1 -	,	(3)	:
7-	a) Closure of 1" Main Scam (overlap) ± 1/8"	Helene		t			1		Nov 22/04 Nov. 23/04
	b) Attach ID Patch (ref. CAR 04-003)	NOV 23/04	Bonding .	/		_	i	1 1	Dec 3/04
8-	a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 Nov 29/64	Testing (see sheet 2)	1			1	(A)	Nov 29/04
	 a) Attach I" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8" 	37	7/04-25	1			/	(11)	NN 30/04
	b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag3:	7 Nov.30/04	Bonding	1			1	44	Nov 30/04
		1 4 3 7 1	·	1		_	/	(3°4)	NOV30/04

Rev. D. Sheet 2

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp.	Date
10- a) Final Test b) Inspector to Stamp on ID Patch:	12 Dec 3/0	1			-	1	4	Dec 3 2004
Serial No.: B 2 8 8 2 8 - 6 5 & Inspection Stamp beside the S/N 2 8 2 8 - 6		Testing (see sheet 3)					(S.S)	!
& Inspection Stamp beside the S/NZ1828-0	DIA DECE	04					.1 / /	Dec 6 2004

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high legering and black ink; serial number (7 digits), provided by DART (refer to W/O). A verify the integrity of the Valves (Threads/gaskets

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C, c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- = 0.049 PSI for each 0.1 inch of barometric decrease

		5 Min. Over P. & Soap Test		45 Minute Stabilizing Period			•			111	our Test	·	22 % pum		
Chambers *	Pressure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass Tail	
# 1 (see note 1) Re-Test	4.36 PSI	Pass	3.00 1'SI	12:15	1:00	3.00 PSI	1:00	2:00	3. PSI PSI	aa` əə	J9.88 29.88	-/-	3 651	Pios	
# 2 (Main Scam)	4.36 PSI	Para	3,00 PSI	//:00	11:45	3.00 PSf	11:45	12:45	294 PSI	22 22	29.78 29.79	40.004	2.94 PSI	Bios	
Re-Test					·								<u></u>		

Note 1: Chamber h	I requires Dart A	.crospace Approval Signature: _	Chy Povern	1	Date:	04/11/22	
Observations:	OK			V			

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Оре	ning	Clo		
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	32867	9:50	3,50 PSI	9:55	3.30 PSI	Perso
Chamber # 2 (Main Seam)	32849	12:00	3,49 PSI	12:05	3,17 PSI	Pass

Chambers	Design				24	Hour L	cakage Test			17 %	lung
Decipoo	(closing) Pressure as per above	Time On	Time Off	Read'g		'emp. Barom. art/End Start/End			Adjust.	Final Read'g	Pass Fail
# 1 Re-Test	3,30 PSI	9:55	9:55	2.63 PSI	22	23°	29.24	29.78	+0.054	2.94 PSI	Pass
# 2 (Main Scam) Re-Test	3.17 PSI	12:05	12!05	2.21 PSI	J3 [°]) 	ĺ		-0.102		Pass

5.1											,) §
Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3.5	Riss	47.0	± 0.5	41 314	Pass	24.75	1.0.5	25116	Ress
7.3	1 0.100 *	7. 3	Pass	* = I/W	' QSI 018, re	v. A daugt 03-95-29		31.0	1.0.5	3/.0	Pass

		Subm.Date / @pm	Pass/Fail	Subm.Date / am-6m	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail
-e-	24 hour	novi6/04	Pass	70029/04	Pass				
	7 day	70016/04	Pass	nou 24/04	Pass				
, ä	24 hour	nov 16/04	Pasa	Mar 29/04	Pass				
Š	7 day	nov 16/04	Pusa	nov aglo y	Pass				



Rev. D. Sheet 13

Description: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

w/o:<u>3**B**63</u>

TSS P/N: 8927

Qty.: 1

Customer P/N: <u>D3218-041</u>

Dwg. No.: D3218

Rev.: A

ate: Nov.

	ing IAW PCS 003	Mark	ing IAW PCS 004	Bondi	ing IAW PCS 002	Silkscreen		
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date	
.85	NEULAN			(Deem	nantad balan V	N 11 M		

^{*} Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) a) Attach Panel Λ (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	37 17 nov.04		1			(,	Nov. 17/04
b) Attach (6) Valve Flanges on Panel Λ: 2-Relief, 2-Inlet & 2- Topping Up	37 16 NOV. 64		6	T-systems	J - w	6		Nov. 16/04
c) Attach (6) Doublers on above Flanges	37 16 nov-c	Bonding	60	 -		6		160.17/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 /7 NEV.CY	7104-25	1		- 170 L	(601.17/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	3+17 now 04	<u>L</u> . '	1			1		Nov. 7/04
4- a) Baffle Ass'y, with 2" Tape ± 1/8"	117	**	1	artinymin -		1	(11)	Nov 17/04
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	187100-104	Bonding	/			/	1 1000	Nov. 18/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 mor/64	Testing (see sheet 2)	1			,	V S & X	,
7- a) Closure of 1" Main Scam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)	23/10004	Bonding	/				X55	Nov 23/04 Nov 23/04
	3 dec /04				apr		Ass	Dec 3/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 Nov 27 2004	Testing (see sheet 2)	1			1	A	NOV 27/84
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	37 Nov 29/01	7104-25	1	-				NN 29/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bagg	- Nov 29/04	Bonding	1			/	77	NOV 29/04
c) Attach 5" split patch on each end $(x 4)$ 37	Nov 27/04		/			/	1-30	Nov 29/09

Rev D Sheet 2

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp.	Date
10- a) Final Test b) Inspector to Stamp on ID Patch:	12 Decap	g Testing					(A)	Dec a Dooy
Serial No.: B2/828-061828-(& Inspection Stamp beside the S/N21828-((see sheet 3)					ASS.	
& Inspection Stamp beside the S/NZ1828	1612 Dec/6/	04			337433	s Visite the in	longite of the	Values (Threads gaskets).

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high leftering and black into serial number (7 digits), provided by DART (refer to W/O). Verify the integrity of the Valves (Threads gas

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the HC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.049 PSI for each 0.1 inch of barometric increase
- + 0.054 PSI for each 1°C of temperature decrease
- 0.049 PSI for each 0.1 inch of barometric decrease

		5 Min Over P. & Soap Test	i	45 Minute bilizing Per						1 Ho	ur Test			20	% keing
Chambers	Pressure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Bard Start/		Adjust	Final Readig	Pass Fail
# 1 (see note 1)	4.36 PSI	Casa	3,00 PSI	12:15	1:00	3.00 PSI	1:00	2:00	2.94 PSI	22° 23°	29.88	29.88		2.94 PSI	faes
Re-Test Mar 27/04 # 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	9:10	9:55	3.00 PSI	9.55	10:55	2.99 PSI	22 22	30.13	30.11	-0.009	2.98 PSI	Basi
Re-Test		•													

Note 1: Chamber #	41 requires Dar	t Aerospace Approval Signatur	e: <u>Cha</u>	Prome	l.	Date: <u>04/11</u> /	122
Observations:	OK	•		·			

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		01	pening	CI	osing	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	30166	8:40	3,39 PSI	8:45	3,/3 PSI	Pass
Chamber # 2 (Main Seam)	32864	9:10	3.45 PSI	9:15	3,19 151	Pass

Nov 30/00 Chambers	Design (closing) Pressure				24 Hour I	Leakage Test		17%	huma
	as per above	Time On	Time Off	Read'g Temp. Start/End		Barom. Start/End	Adjust.	Final Read'g	Pass Fail
# 1 Re-Test	8:13 PSI	8:45	8:45	2.73 PSI	22" 22"	30.06 29.29	-0.377	2.35 PSI	Pass)
# 2 (Main Seam) Re-Test	3:19 PSI	9:15	9:15	1.95 PSI	33° 33	29.30 29.74	to.054 + 0.225	2.22 PSI	Possi

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	上 0.100 *	3.5	Pacis	47.0	± 0.5	47.0	Pess	24.75	1.0.5	15.25	7055
7.3	1 ± 0.100 *	7.5	FASS	* = I/W	QSI 018, re	v. A dated 03-05-29	(0)	31.0	1 0.5	31,5	Pass.

		Subm.Date /@D-pm	Pass/Fail	Subm.Date / am-pյյմ	Pass/Fail	Subm. Date / an Ain	Pass/Fail	Subm.Date / am-ging	Pass Tail
Peel	24 hour	nov. 7/04	Para	716017101	Puas	NOV 18/04	Pass	7100 29/04	Purs
	7 day	70017104	Pura	100 (7/04	Pass:	710018/04	1/622	700 29/04	Ness.
Shear	24 hour	710017104	Pass	710017104	Pass	nav 18/01	Fasa	7100 24/04	Pasa
	7 day	20017/04	Pass	NOV17104	Pars:	Tue 0 18/04	Pans	now 24/04	Prisa